

Work Order ID 54279

December 7, 2009 1:19:17 PM



Page 1

Item ID:	D2580-1	Accept		Setup	Start				
Revision ID:					Stop				
Item Name:	205 Skidtube bent detail								
Start Date:	07/12/2009	Start Qty: 2.00		Cust Item ID:					
Required Date:	10/12/2009	Req'd Qty: 2.00		Customer:					
Reference:									
Approvals:	Process Plan:	Date: 07/12/09	Tooling:	Date:	Run	Start			
	QC: _____	Date: _____	SPC (Y/N):	Date: _____	Stop				
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 		0.00							
HandFinish 	Memo	0.00							
Hand Finishing	1- Inspect mat'l D2500-1-190 for damage. 2- Chemical Conversion Coat as per QSI 005 4.1								
101 	QC3- Inspect Part Finish	0.00							
QC 	Memo	0.00							
Quality Control									9-12-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54279

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Page 2

Item ID: D2580-1

Accept



Setup Start



Revision ID:

Item Name: 205 Skidtube bent detail

Stop



Start Date: 07/12/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run Start



Stop

Sequence ID/
Work Center ID

110

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

Skidtubes

Memo

0.00

1-Drill pilot holes using drill jig DT 8149 (Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580 without cutting fluid

3-Deburr and blow out all chips from inside of tube

4-Bond web in place per QSI 015.

□

□

112395

A/R Sikaflex-291 batch:

□

Sikaflex expire date:

Start time: 3:40 bond for 12hrs

20-02-10

AWM 7-12-10

130



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

(2)

BE 09/12/11

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Page 3

Item ID: D2580-1

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Setup Start



Revision ID:

Item Name: 205 Skidtube bent detail

Start Date: 07/12/2009 Start Qty: 2.00



Stop



Required Date: 10/12/2009 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: 46

0.00

2

09/12/11



Packaging

Memo

0.00

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/12/11 JJ

MF 09-12-11

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Picklist Print

December 7, 2009 1:19:21 PM

Page 1

Work Order ID: 54279



Parent Item: D2580-1



Parent Item Name: 205 Skidtube bent detail

Start Date: 07/12/2009

Required Date: 10/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2500-1-190



Manufactured

No

Each

110.0000

2.0000

Ext'n -I Beam Tube 4"

Warehouse

Location

Main Warehouse

LG

Loc Qty

Loc Code

107

32 12/12/10

50166
52319

6

101

Main Warehouse

ST

3

46468

3

110

Each

1.0000

2.0000

D2596



Manufactured

No

Web, 205 Skidtube

Warehouse

Location

Main Warehouse

LG

Loc Qty

Loc Code

1

53263

1

(d)
B-53881 AwM
9-12-10

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

DART

DESIGN <i>#</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AEELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP C/P
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK
NO. *541279*

*07.09.127***GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

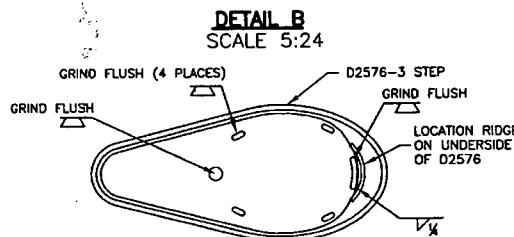
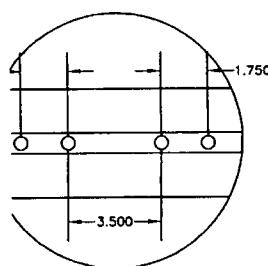
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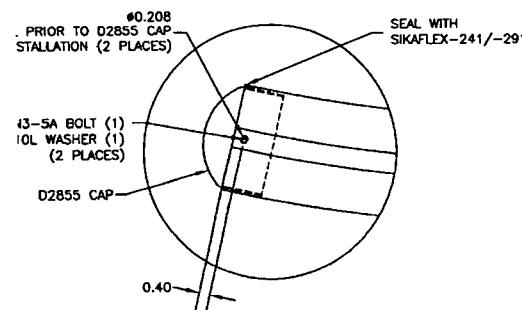
W/0 54279

DETAIL A
SCALE 5:24

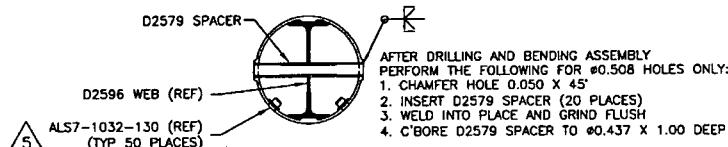


RELEASED
07-06-28-1

DETAIL C
SCALE 5:24

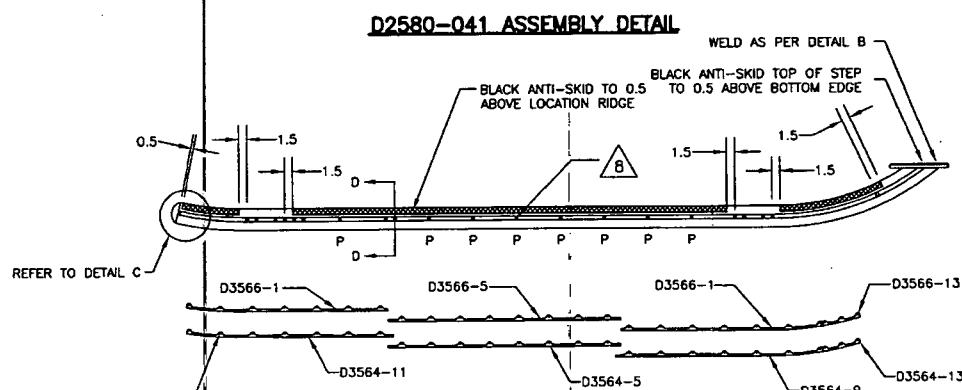
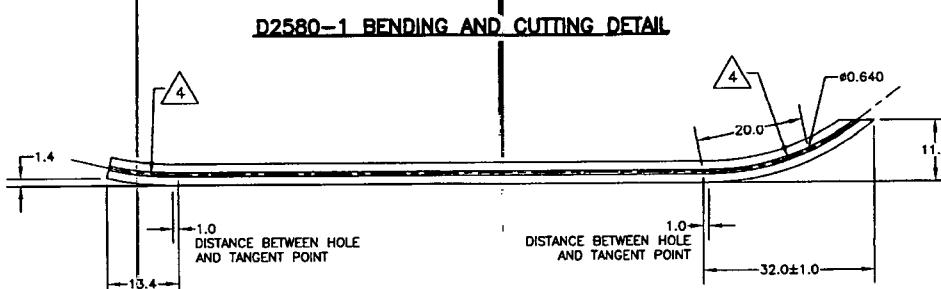
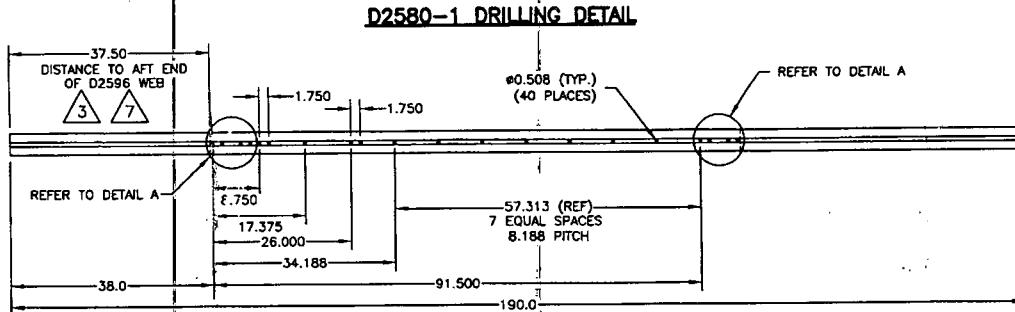


SECTION D-D
SCALE 5:24



-041 NOTES

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4



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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED		DRAWING NO. D2580
DATE		REV. 0 SHEET 2 OF 3	TITLE 205 SKIDTUBE ASSEMBLY SCALE 1:24

07.02.27

W/O:		WORK ORDER CHANGES							
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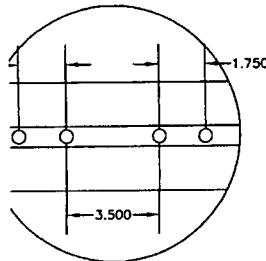
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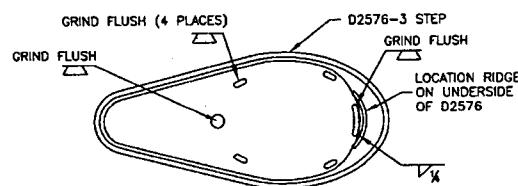
W/0 54279

DETAIL
SCALE 5:24

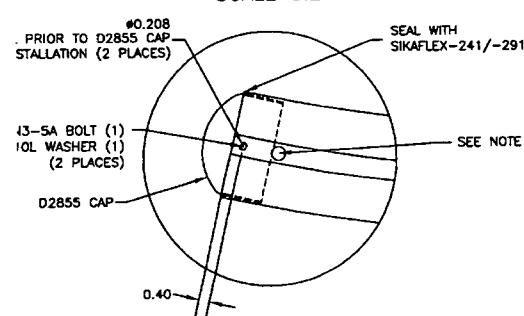


RELEASED
07-06-28

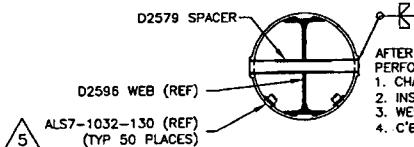
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24



SECTION H-H
SCALE 5:24

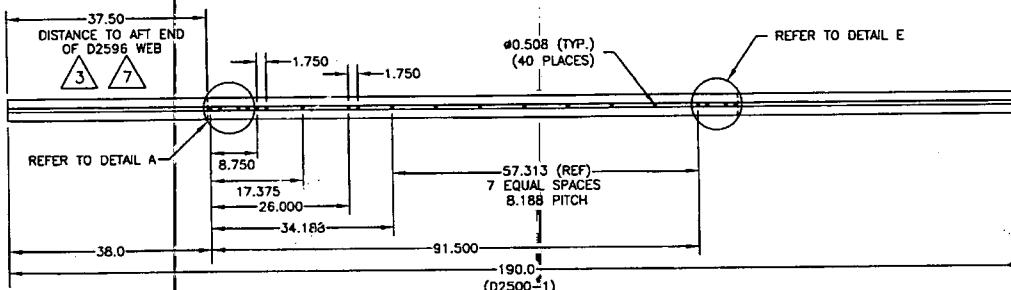


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE .050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

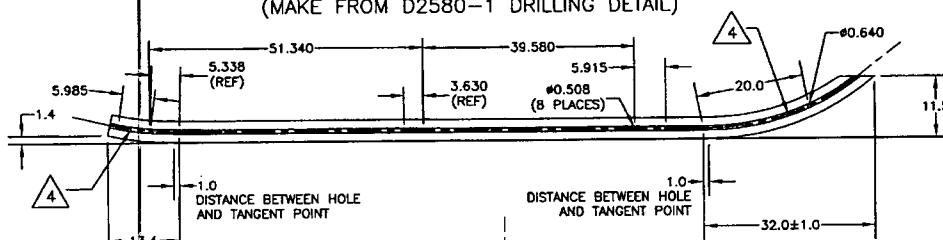
-045 NOTES

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

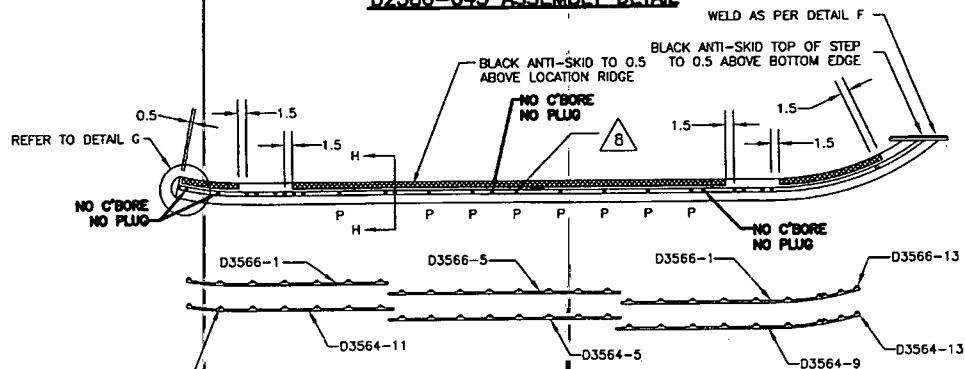
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DESIGN
P/I

F.D.

11

DATE

PART

DART AEROSPACE LTD.
HAMMERSLEY, ONTARIO, CANADA

DRAWING NO.

REV

D2580

SHEET 3 OF

205 SKIDTUBI

ASSEMBLY

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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